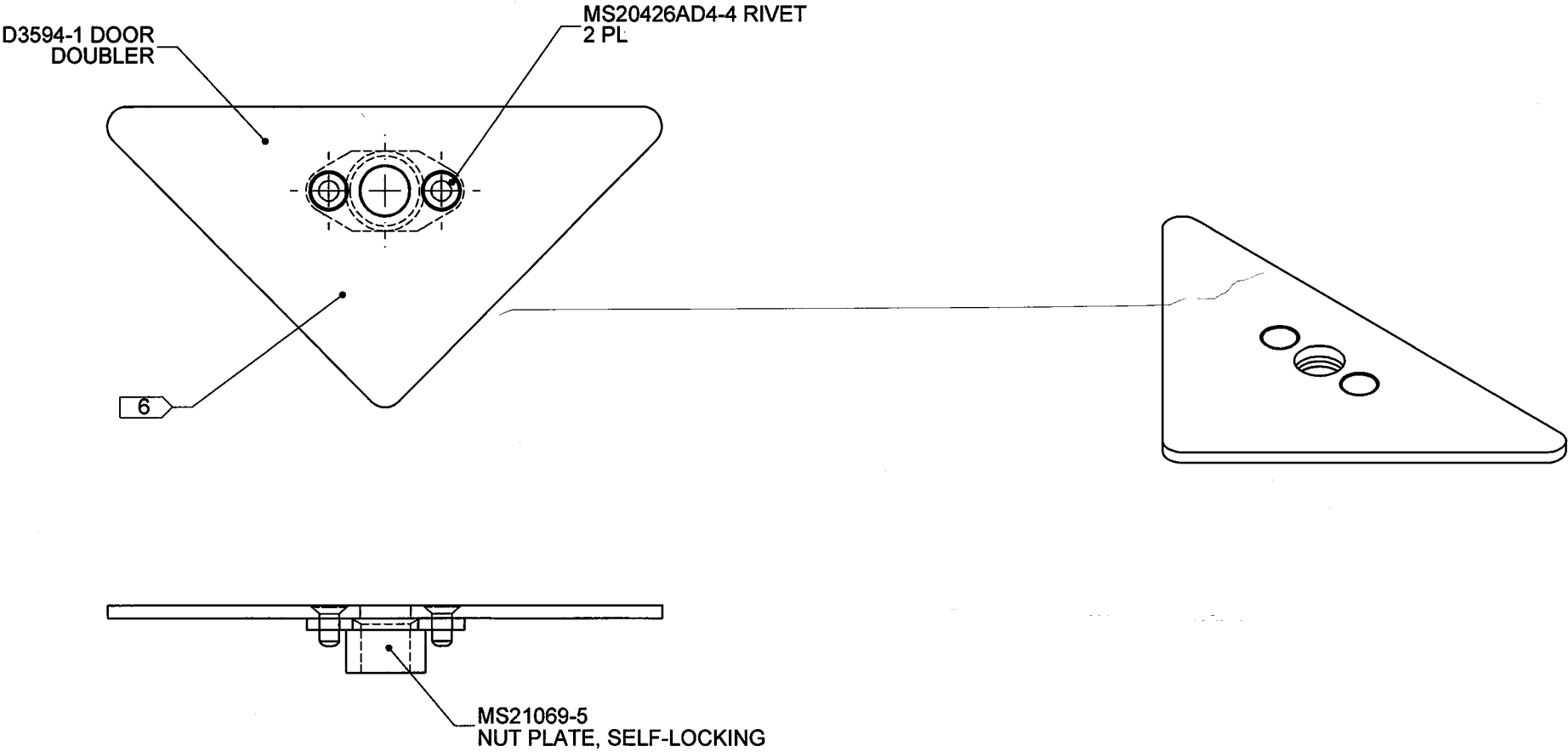


ITEM	QTY -041	P/N	DESCRIPTION
	X	D3594-041	DOUBLER ASSEMBLY
1	1	D3594-1	DOUBLER
2	1	MS21069-5	NUT PLATE, SELF-LOCKING
3	2	MS20426AD4-4	RIVET, SOLID, CSK



D3594-041 DOOR DOUBLER ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER DART QSI 044
7) WEIGHT: 0.04 lbs

RELEASED

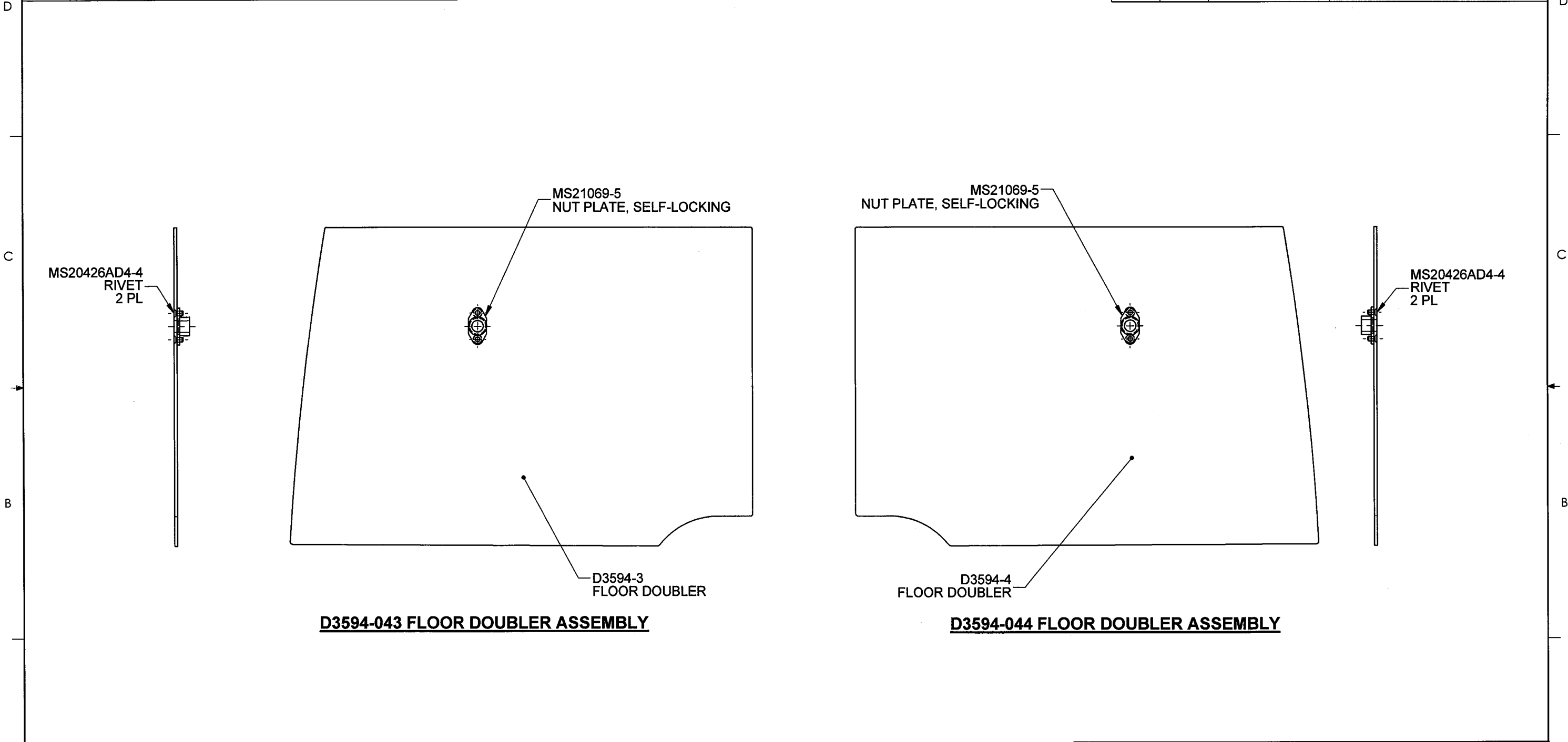
2020 APR 29
Ecn 2020-548

APPROVED

E	ADDED D3594-7 AND D3594-047, AND REORGANIZED SHEET ORDER, REASON CAR20-368	SAD	20.04.02
D	MS20169-5 WAS MS21068L3 (ZN D6-1, B3-1, D6-3, D3-3, C5-3, C4-3). REF PAR16-557	VS	17.04.07
C	REFORMAT TO CURRENT STANDARDS. ADD 0.5" OF MATERIAL TO -3 & -4 REASON PAR16-501.	AJS	16.05.25
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	D3594	SHEET 1 OF 6
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	20.04.02	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3594-043	FLOOR DOUBLER ASSEMBLY
1	1	D3594-3	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069-5	NUT PLATE, SELF-LOCKING

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3594-044	FLOOR DOUBLER ASSEMBLY
1	1	D3594-4	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069-5	NUT PLATE, SELF-LOCKING



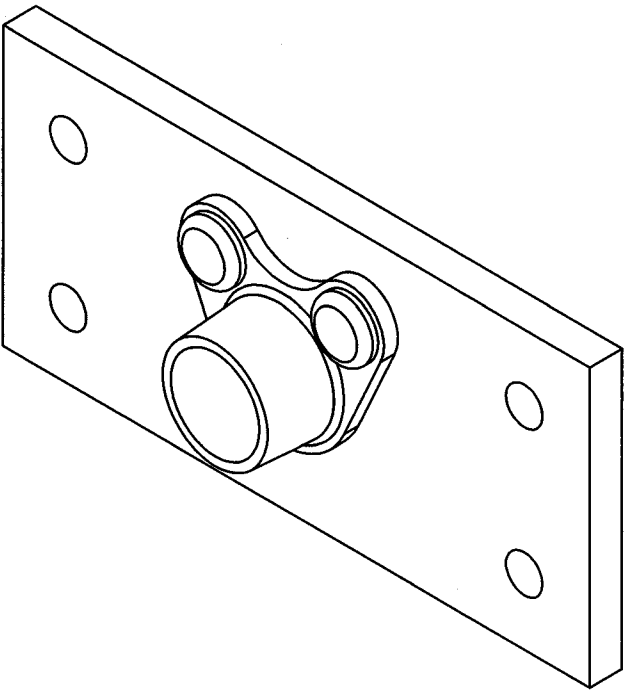
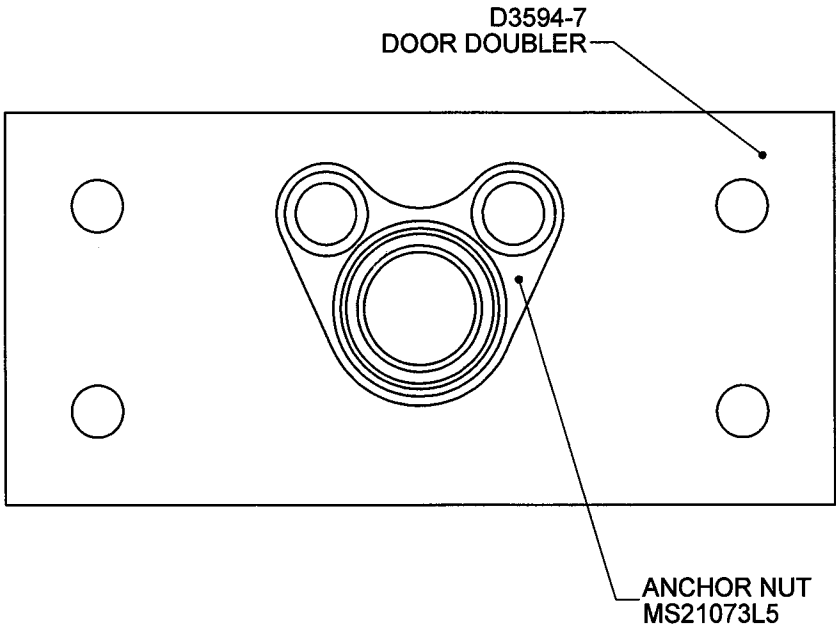
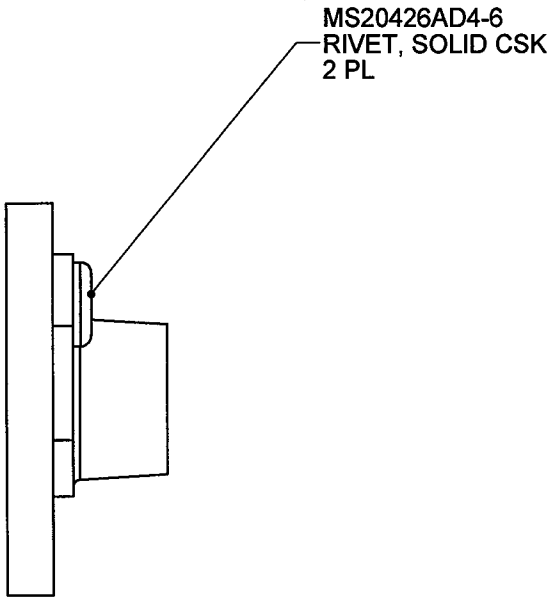
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER DART QSI 044
7) WEIGHT: 0.82 lbs

RELEASED
2020 APR 29

APPROVED

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	D3594	SHEET 2 OF 6
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D3594-047	DOOR DOUBLER ASSY
1	1	Figure 2 DSI 9847	DOOR DOUBLER
2	1	MS21073L5	ANCHOR NUT
3	2	MS20426AD4-6	RIVET, SOLID, CSK



D3594-047 DOOR DOUBLER ASSEMBLY

E

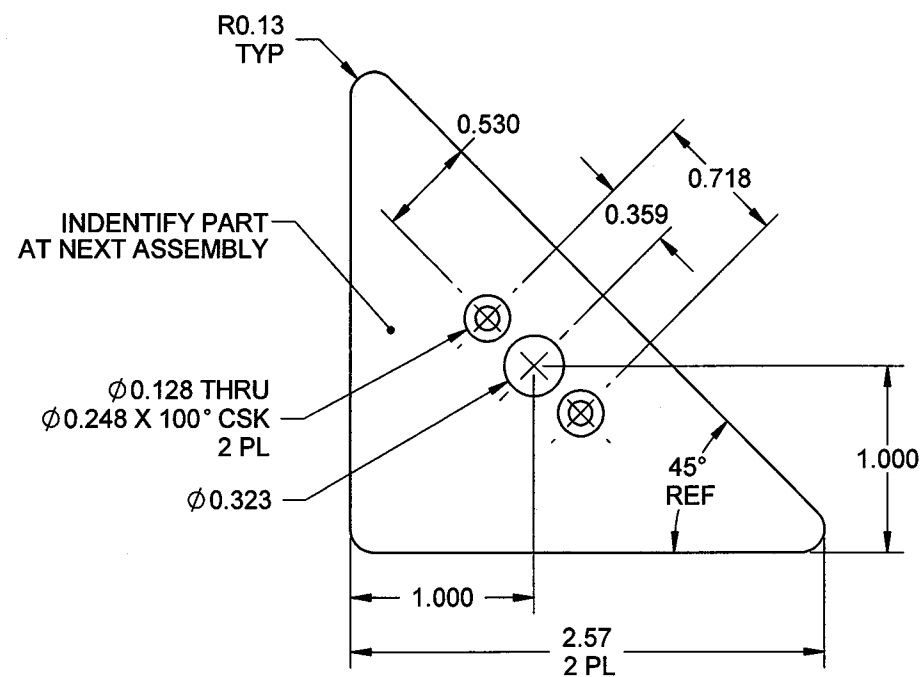
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.82 lbs

RELEASED

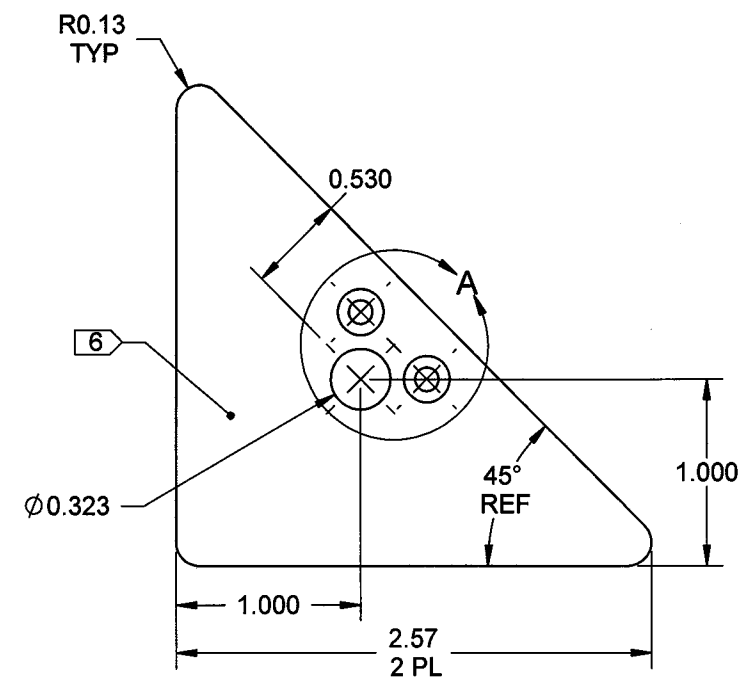
2020 APR 29

APPROVED

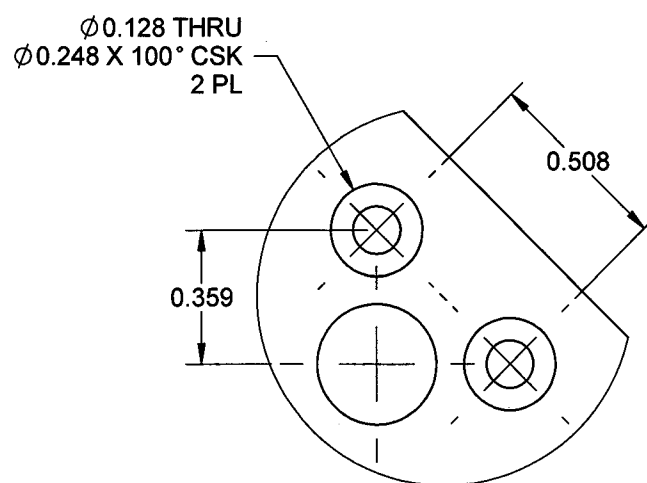
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO. D3594	REV. E
MFG. APPR.	DD		SHEET 3 OF 6
APPROVED	VS	TITLE DOUBLER	SCALE NTS
DE APPR.	DS		
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D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER



**DETAIL A
SCALE 2X**

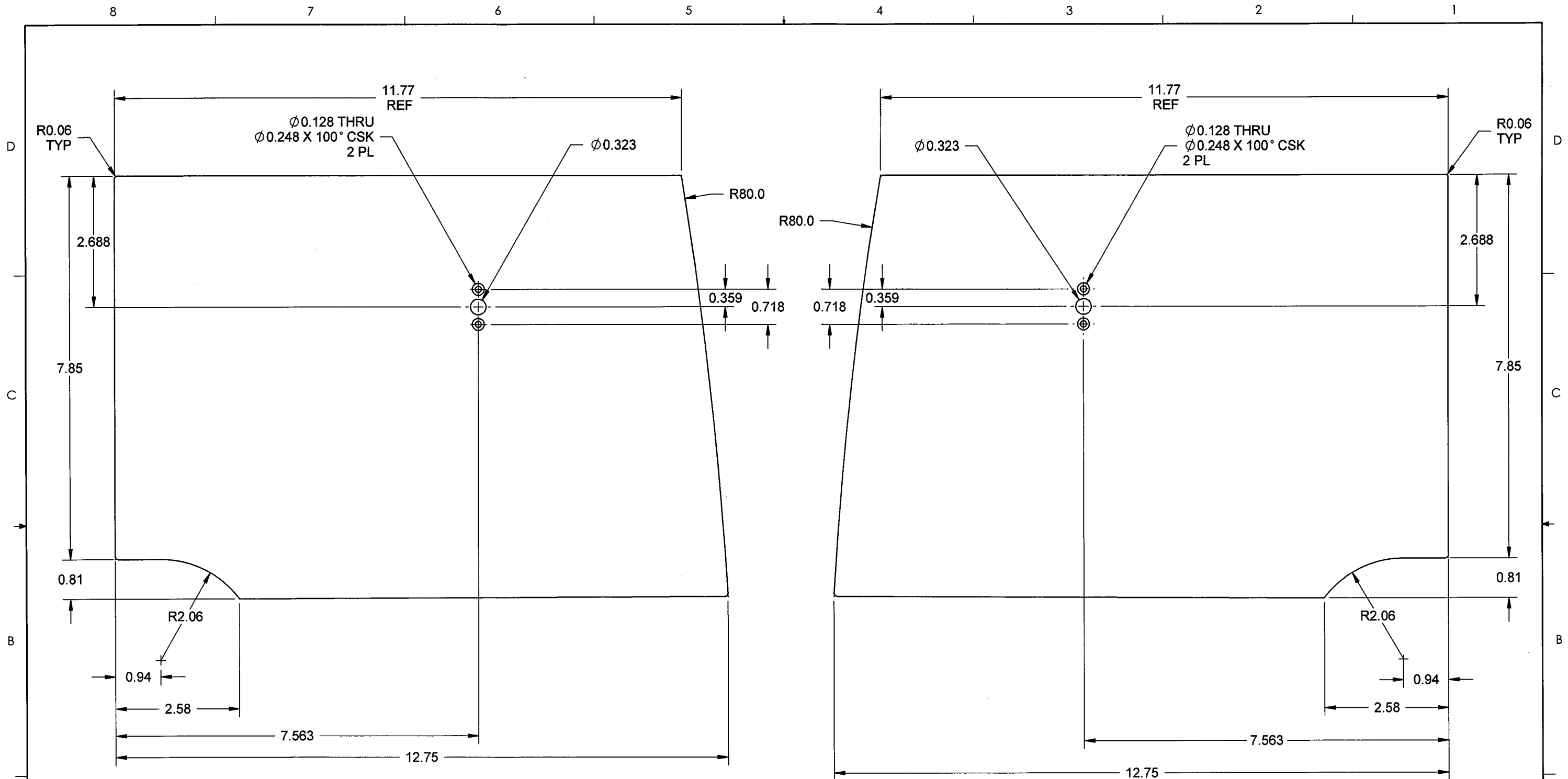
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION -5 ONLY: IDENTIFY PER DART QSI 044
 - 7) WEIGHT -1/-5: 0.03 lbs

RELEASED

2020 APR 29

APPROVED

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO. D3594	REV. E
MFG. APPR.	DD	SHEET 4 OF 6	
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	20.04.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3594-3 FLOOR DOUBLER

D3594-4 FLOOR DOUBLER

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: 0.82 lbs

RELEASED
2020 APR 29

APPROVED	DESIGN	MB	DART AEROSPACE LTD	
	DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	MB	DRAWING NO.	REV. E
	MFG. APPR.	DD	D3594	SHEET 5 OF 6
	APPROVED	VS	TITLE	SCALE
	DE APPR.	DS	DOUBLER	NTS
DATE		20.04.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

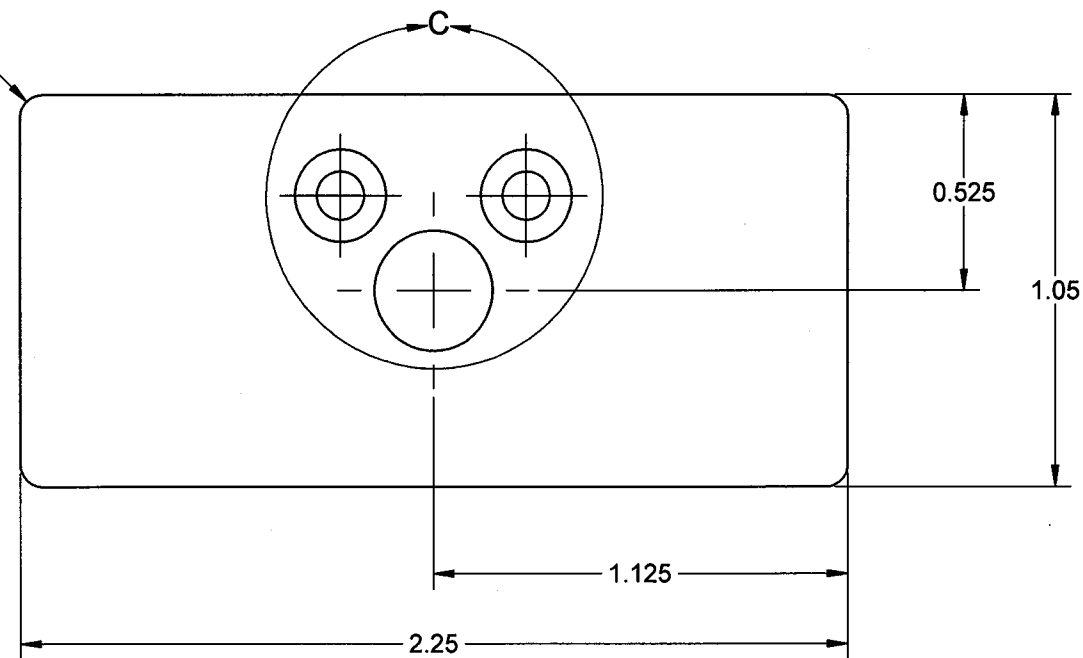
D

C

B

A

R0.060
TYP



D3594-7 DOOR DOUBLER

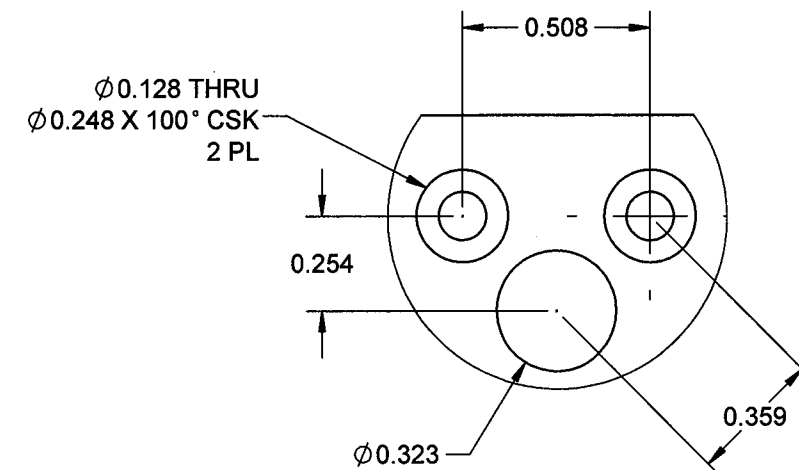


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2020 APR 29 *q1*

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK,
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: 0.03 lbs



DETAIL C

APPROVED

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	D3594	SHEET 6 OF 6
APPROVED	VS	TITLE	SCALE
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